

2025 RELEASE UNDER E.O. 14176

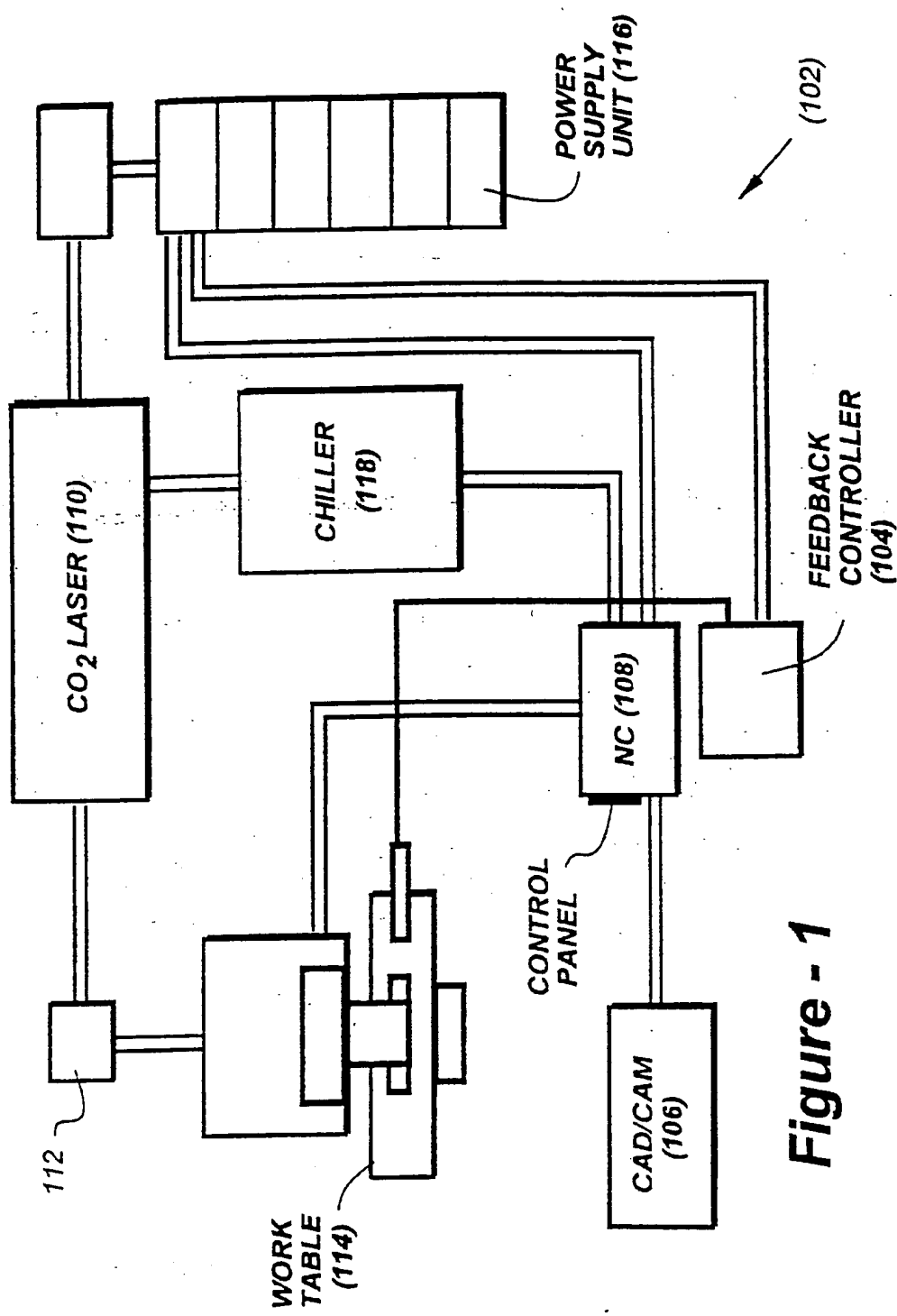
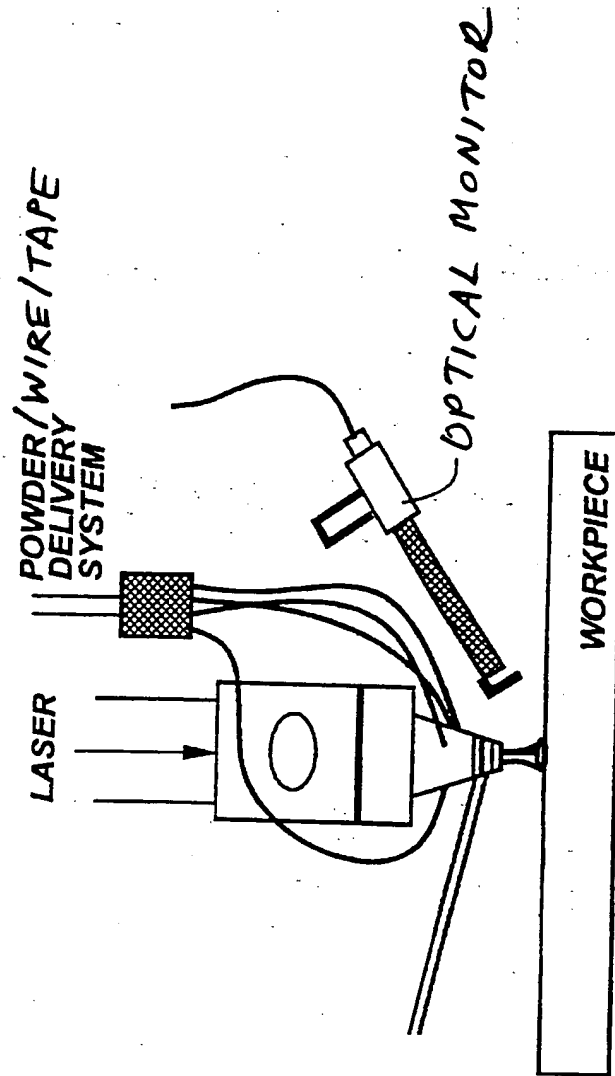
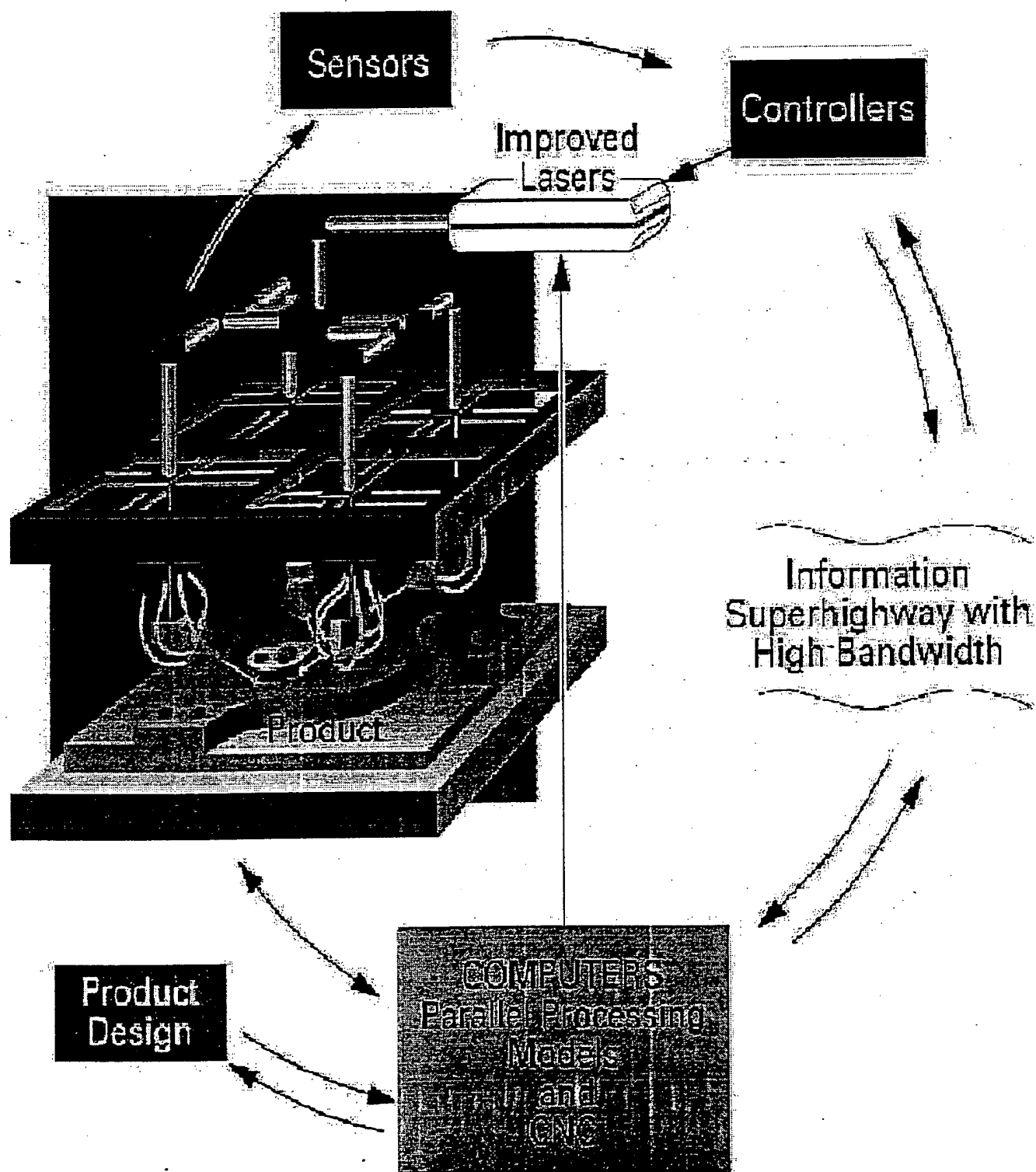


Figure - 1

[illegible]

Figure - 2





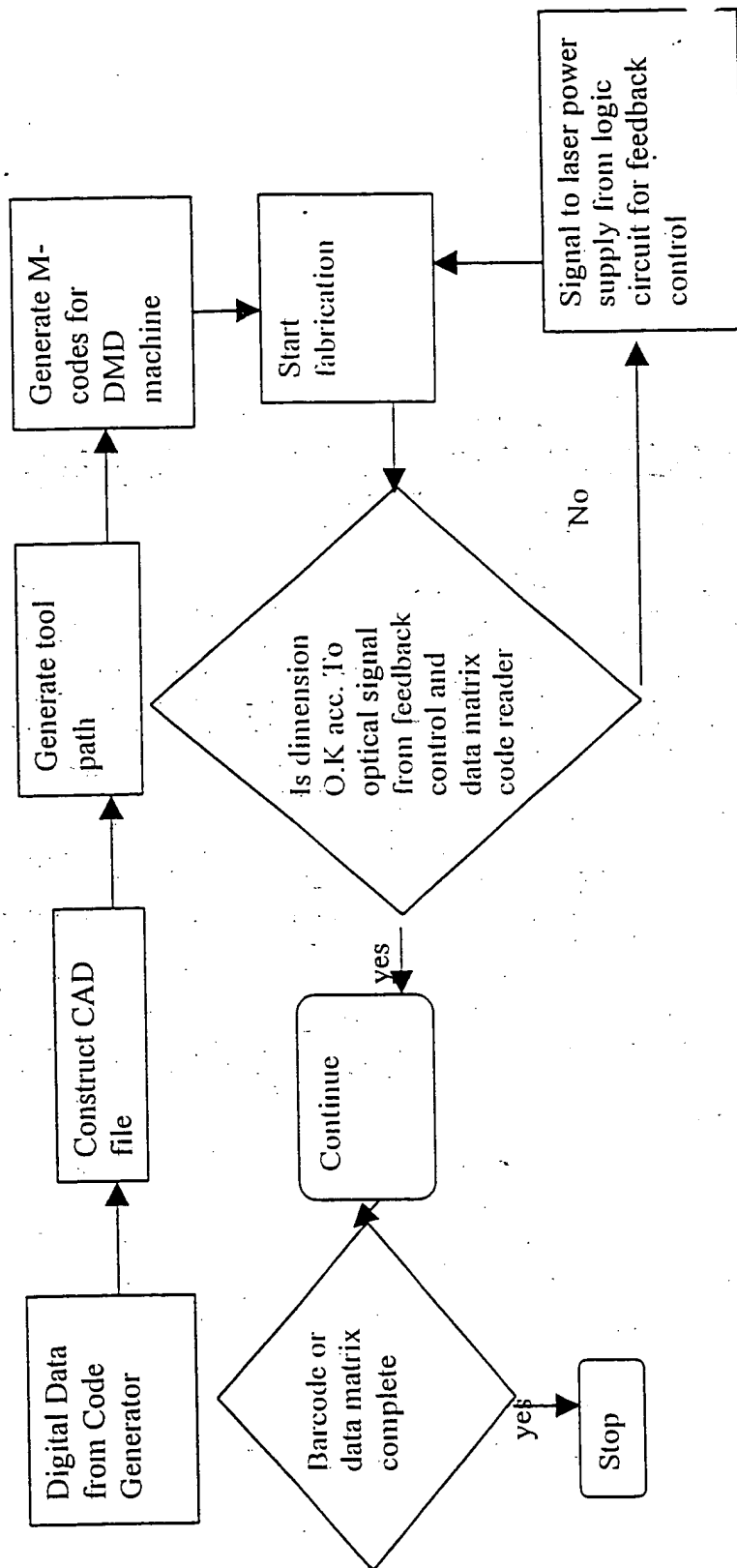


FIGURE 5



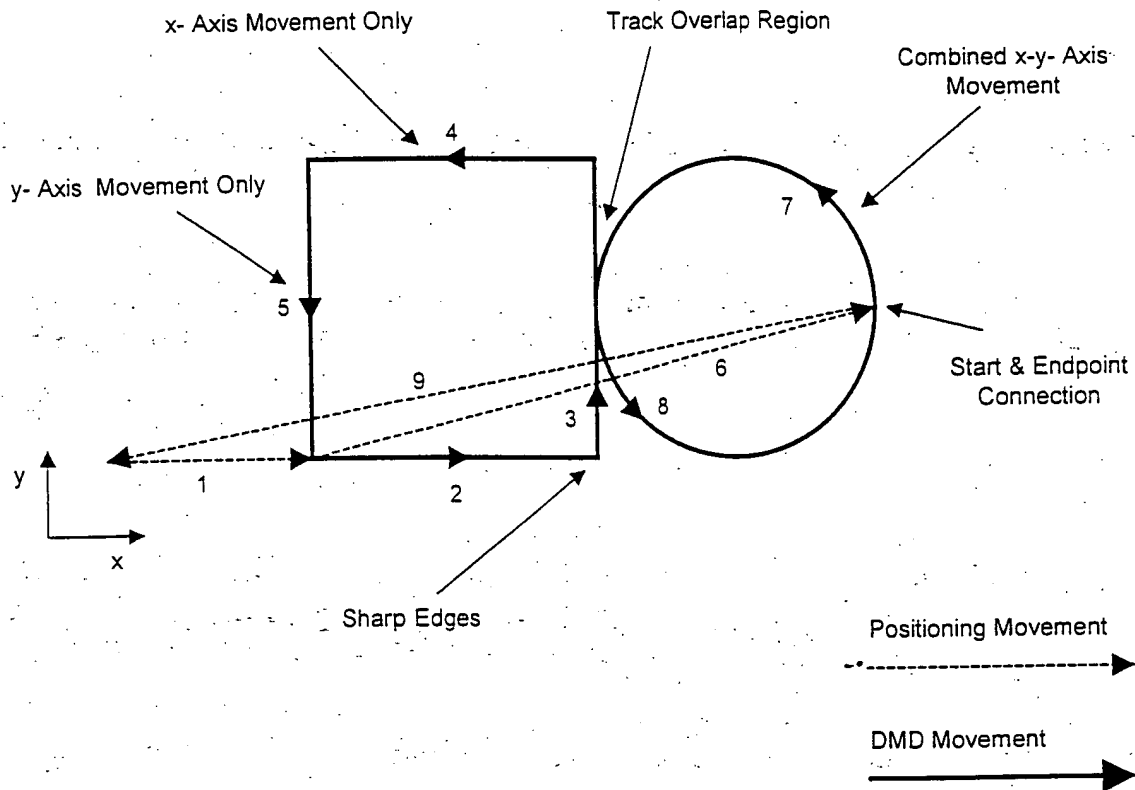
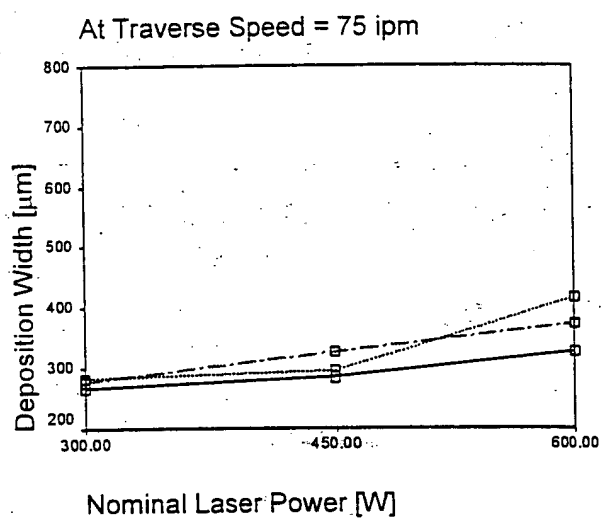
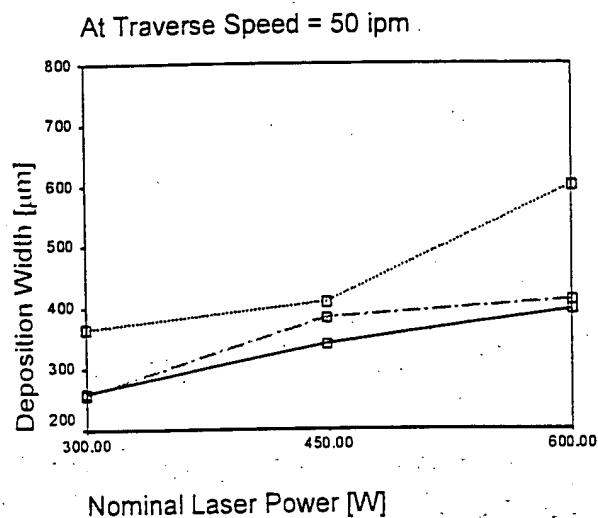
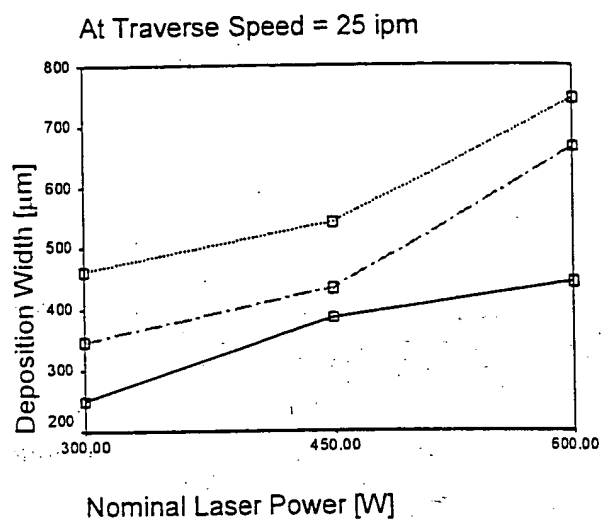


FIGURE 6



Powder Feed Rate [g/30s]

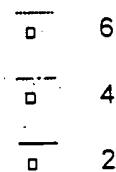
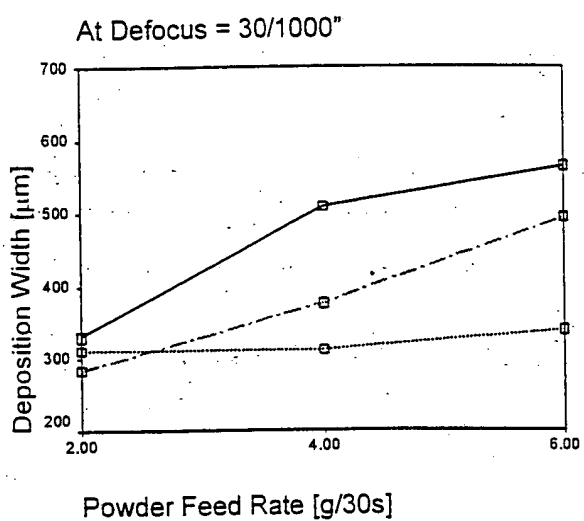
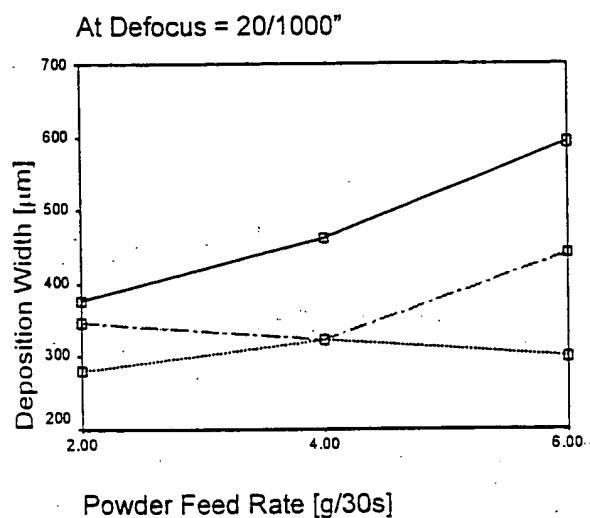
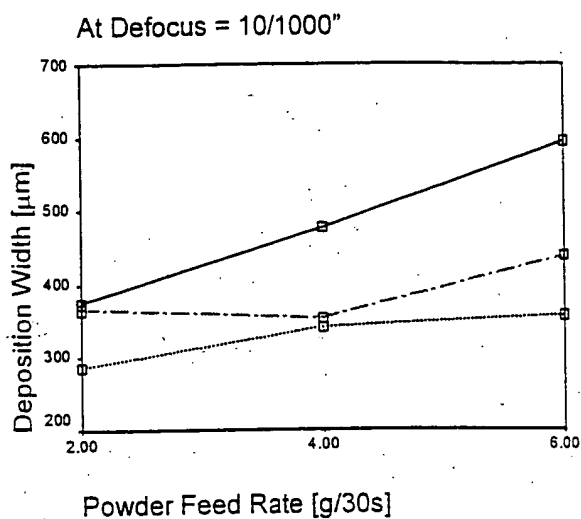


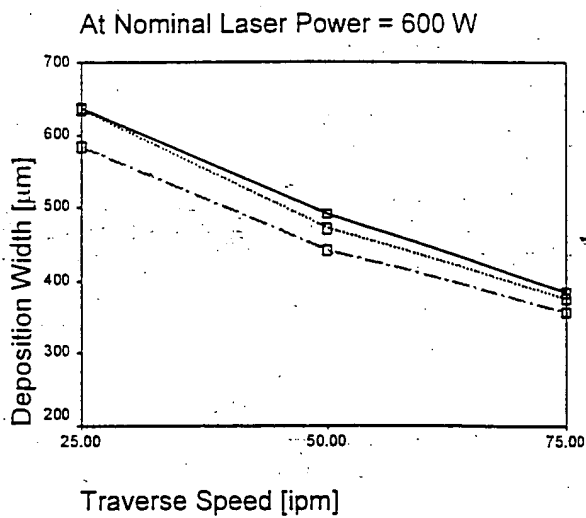
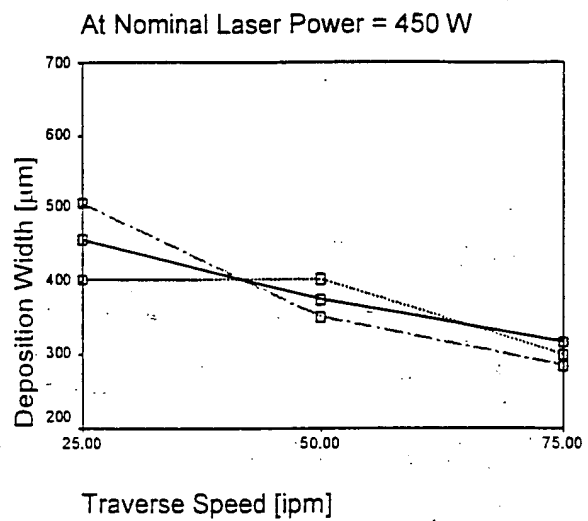
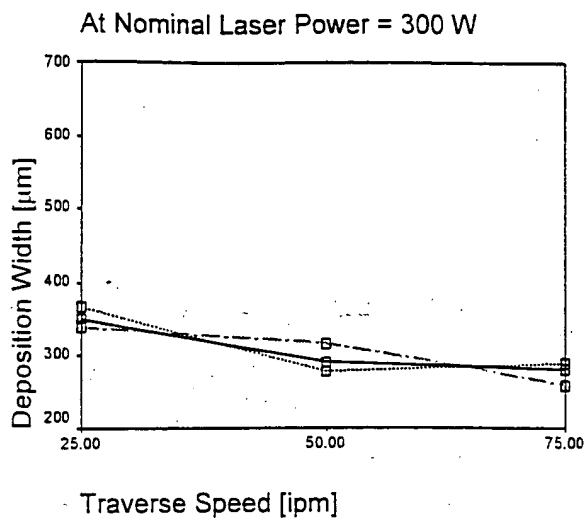
FIGURE 7



Traverse Speed [ipm]

- 75
- 50
- 25

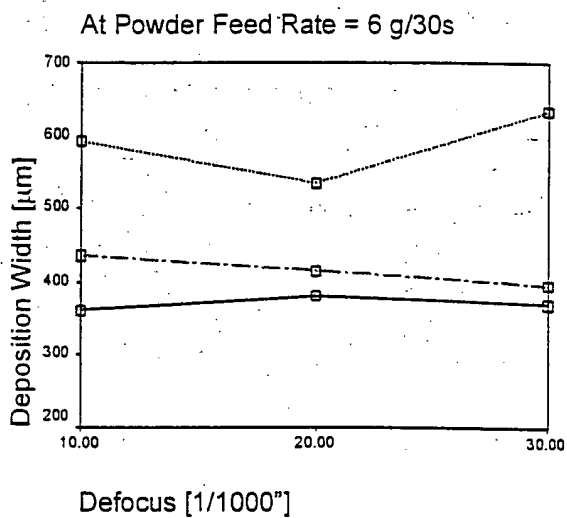
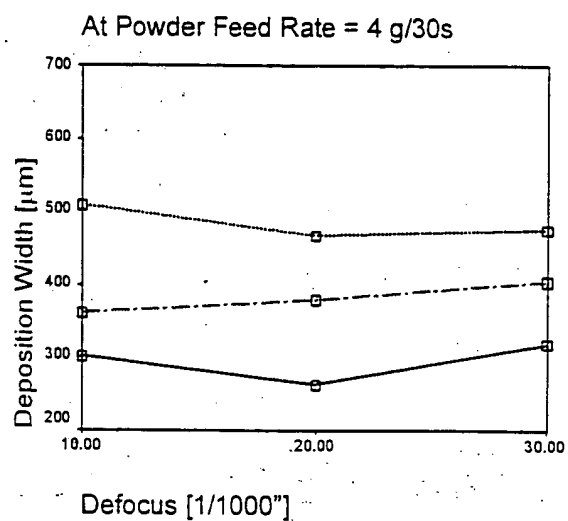
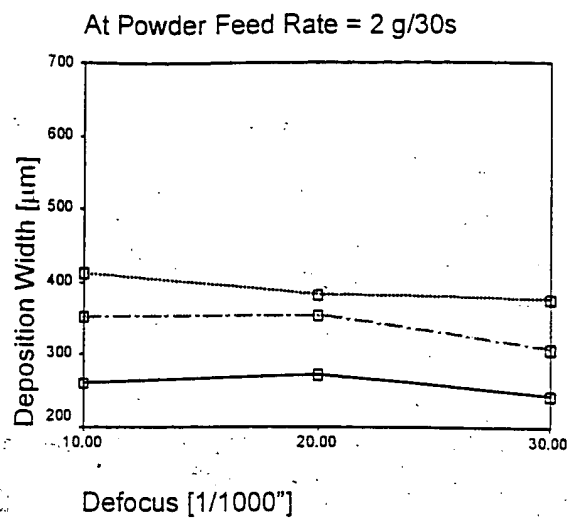
FIGURE 8



Defocus [1/1000"]

- 30
- 20
- 10

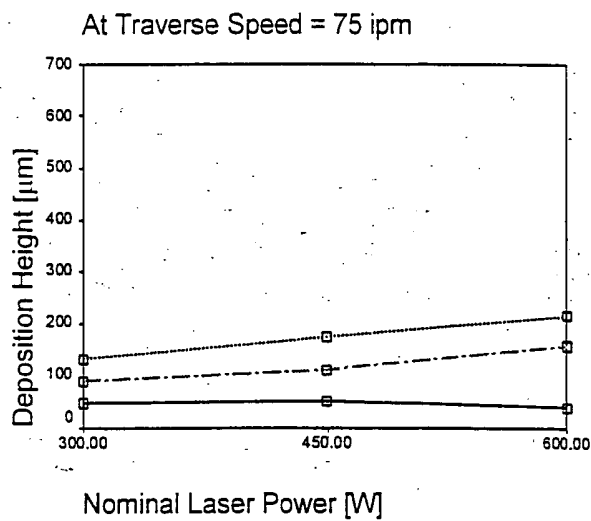
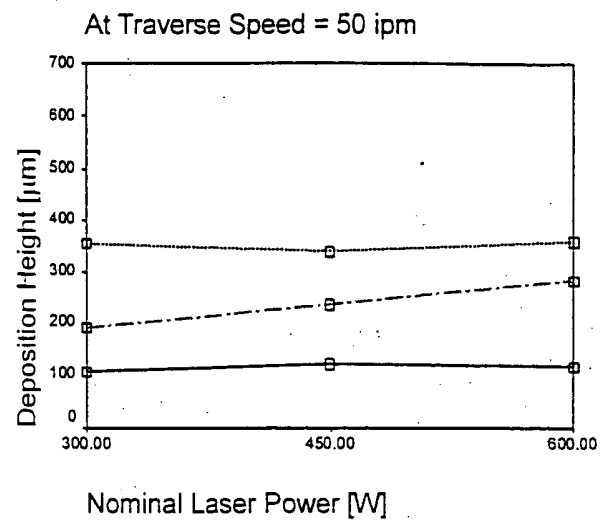
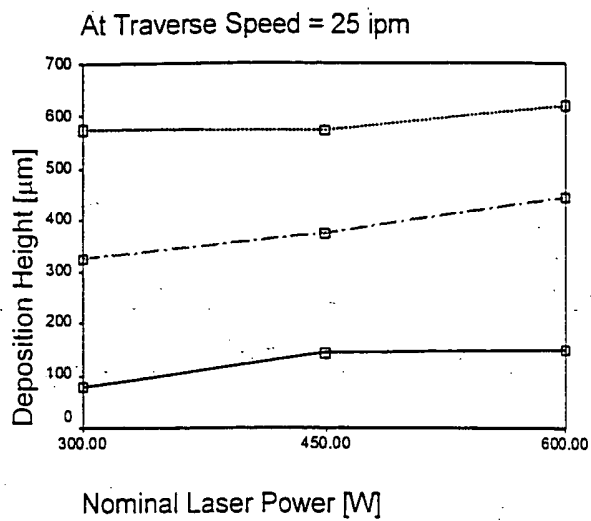
FIGURE 9



Nominal Laser Power [W]

- 600
- 450
- 300

FIGURE 10



Powder Feed Rate

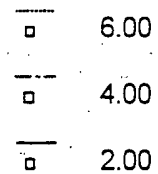
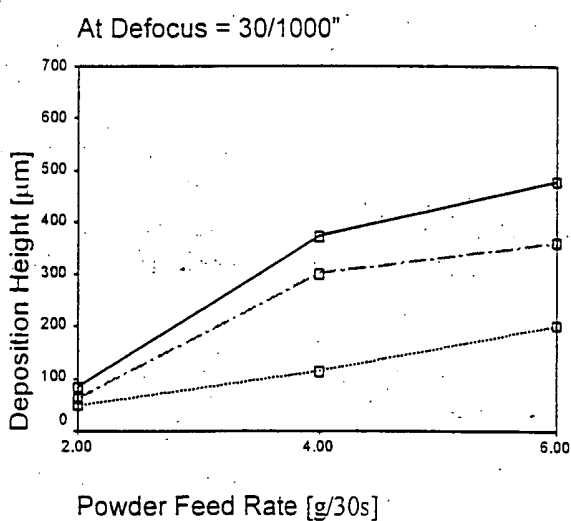
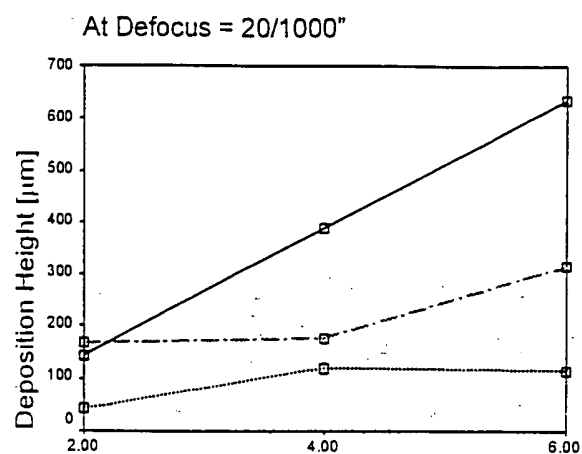
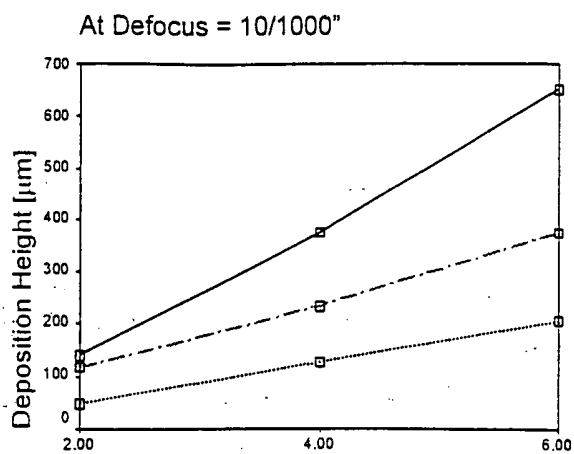


FIGURE 11

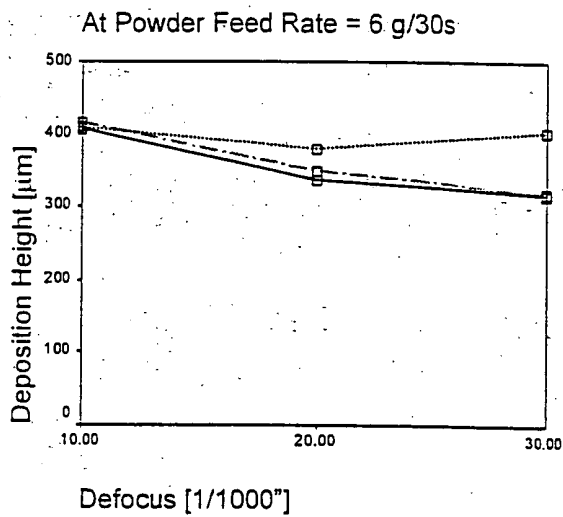
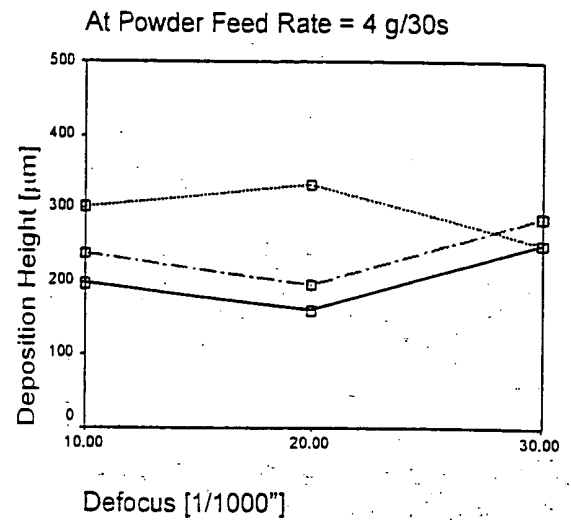
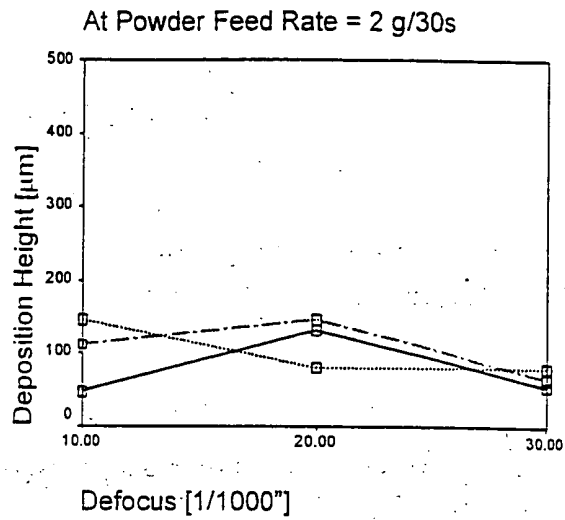


Traverse Speed [ipm]

- \square 75
- \square 50
- \square 25

FIGURE 12

FIGURE 13



Nominal Laser Power [W]

- 600
- 450
- 300

FIGURE 14